

Date: Wednesday, 3/8/2006 10:38:50 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLANGE PLATE
<b>Job Number</b> :	26130		
<b>Estimate Number</b> :	12235		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D34771
<b>This Issue</b> :	3/8/2006	<b>Drawing Number</b> :	D3477 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	N/A	<b>Material</b> :	N/A
	<b>Type</b> :	<b>Due Date</b> :	3/31/2006
	PURCHASED PARTS	<b>Qty:</b>	10 Um: Each
<b>Written By</b> :	SEE COMMENT BELOW		
<b>Checked &amp; Approved By</b> :	06.03.08		
<b>Comment</b> :	Est Rev:A New Issue 06-02-07 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** Issue P/O: 00000768 06/03/09  
 E-mail or Ship DXF file to vendor  
 Laser cut flat pattern as per Dwg D3477  
 Possible supplier: Ind. Laser  
 Material release note is required.

2.0	D34771F	Flange flat pattern
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

06.03.22 (10)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

06.03.22 (16)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Form as per Dwg D3477 using Dt8858 A,B&C

06.03.22 (17) 170

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		On Lab for template	VB	06.03.21	1	VB 06.03.21	VB 06.03.21
		ADD inspection level 21	EE	06.04.23			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE PLATE

Job Number: 26130

Part Number: D34771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/03/30

8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06-03-29

Job Completion



Inspection Level 21 06/03/30

U 06/03/30

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

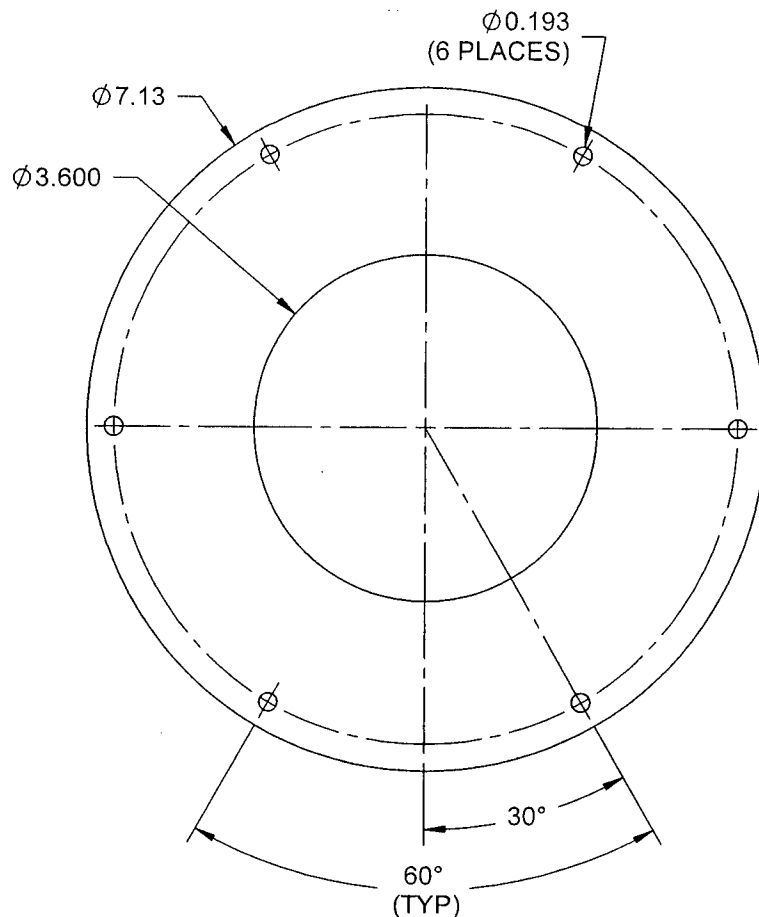
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

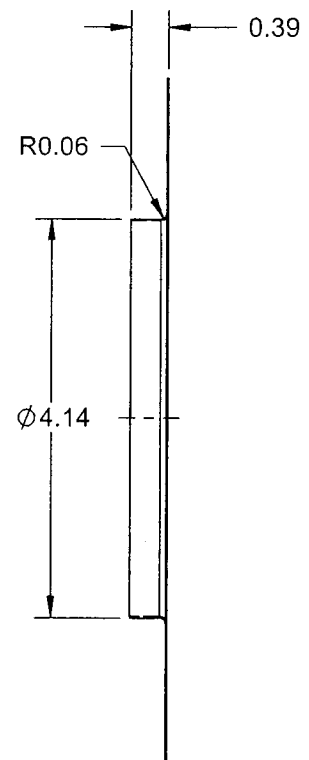
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3477</b>	REV. A SHEET 2 OF 4
DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2



**D3477-1F FLANGE**  
**FLAT PATTERN**



**D3477-1**  
**FLANGE**

**NOTES:**


- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**MAY-17-2005 16:05**

## PROB-INTERIS

**253-288-8888**

**T-726 P. 007/015 F-587**

		<b>AK Steel Corporation</b> Metallurgical Test Report Cooshoon Works Cooshoon, OH 43812		Fig 1 Lead No. 710672 SRN No. 710672	
INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440 INTEGRIS METALS 306 R STREET ALBANY, WA 98001		MILL ORDER NO. 77134-0191 PROTECTOR ORDER NO. 427135-01 PURCHASE ORDER NO. 427135-01 PART NO. 77134-0191 EXHAUST UNITS - 3 PRODUCT - 3 METAL UNITS 410000 4000 X COIL		SKID ID PECE HEAT PARENT COIL ID NET WEIGHT	
SKID1513	1	770051	050019-01	210000, 4012 KG.	
SKID1514	1	770051	050019-01	210000, 4012 KG.	
SKID1515	1	770051	050019-01	210000, 4012 KG.	
SKID1516	1	770051	050019-01	210000, 4012 KG.	
SKID1517	1	770051	050019-01	210000, 4012 KG.	
SKID1518	1	770051	050019-01	210000, 4012 KG.	
TOTAL SKIDS	7			TOTAL NET WEIGHT	
	4			350000, 1600 KG.	
(Large Analysis of Heat) P-Product Analysis Parent Coil <b>CHEMICAL ANALYSIS</b>					
CO	CU	N	MO	NI	CR
0.12	0.30	0.04	0.35	0.05	0.18
0.49	1.39	0.07	0.01	0.35	0.18
REMARKS NO INTENTIONAL ADDITIONS OF MERCURY OR ELEMENTS CAPABLE OF FORMING LOW MELTING SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.					
<b>PRODUCT DESCRIPTION</b> CR SET TYPE 304 SEAMLESS 28 SIMILAR SILEX ROSE & AND 3012 & ALL TACK HOOKS HAVE BEEN MET UNLESS NOTED OTHERWISE & A STM 240-04 EX PARA 3.1.5 BLOWN WILL BE DETERMINED BY BOTH E & 9 & AFTER A 400-01 EX PARA 19.1.1 BLOWN WILL BE DETERMINED BY BOTH W & 8 EX PARA 28.1.3 COIL WILL BE TACKED ON ORGAIN ONLY & AFTER W 866-03 & IN-011 NEW O, & IN-011 O & BURNER PART# 75251497 & AFTER SA-240 SECTION II PART B (2001 XD, 2002 ADDENDUM) EX PARA 3.1.5 BLOWN WILL BE DETERMINED BY BOTH E & 8 & IN-10204 3.1.5					
PARENT COIL	304	008	CONO	2 INCH	2 INCH
ID	1513	1514	1515	1516	1517

INDUSTRIAL LASER P.O. - 110880 S.O. - 374786 ITEM 01 - 3 SHES

604-946-453  
3/13/06  
ATD: JETE

**Fax Server**

3/17/2006 1:57


**Ryerson**

**T-726 P.008/015 F-527**

**253-288-3033**

**FROM INTEGRIS**

**MAY-17-2005 16:05**

		<b>Metallurgical Test Report</b> Coshockon Works Coshockon, OH 43812		Lot# No. 741072 BRN No. 741072	Page 2
INTERMETS METALS PO BOX 100 MINNEAPOLIS, MN 55440		SINTERED METALS 306 B STREET AUBURN, WA 98001		MILL ORDER NO. 177345-0191 PROCESSOR ORDER NO. 427136-01 BUYERS ORDER NO. 427136-01	
REMOVALS		ENGLISH UNITS - PRODUCT - METRIC UNITS 9775 NOD 45000 X COIL 741071		PART NO. 177345-0191	

## MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 1  
Heat/Lot : 86K8  
TIN : B42748

Sold To: INTEGRIS METALS, LTD.  
7910 40TH STREET SE  
CALGARY, AB T2C2Y3

Ship To: \*\*\*CUSTOMER PICKUP\*\*\*  
4375 14TH STREET NORTHEAST  
CALGARY  
ABT3E7A9

### Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

### Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04  
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CROWN MEAS  
CORROSION: ASTM A262/02aB; 180Bend-OK  
Buyer Part: 4288441  
304 2B .1305 IN 48 IN 96 IN  
Country of Origin: UNITED STATES

### Mechanical Tests

		UOM	L	O	UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

### Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

### Comments



# MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 2  
Heat/Lot : 86K8  
TIN : B42748

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A  
This document certifies the material has been tested in  
accordance with applicable specifications described herein  
and has met those requirements.

QA by ERIC HESS 02/01/2006

## Miscellaneous Data

GUELPH, ONT. K123  
Control #: S/C60214  
Part #: 74274441  
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDA LASH

TO 110880

S/O 90-374786 - 02

*[Signature]* 3/17/06

The Chemical Analysis and Mechanical Test  
data was received via EDI from the above  
mentioned vendor.

INTEGRIS METALS, LTD.